

Date: Wednesday, 22/10/2008 1:31:59 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 42822		
Estimate Number	: 12966		
P.O. Number	:	Part Number	: D3637041
This Issue	: 22/10/2008 S.O. No. :	Drawing Number	: D3637 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 37310	Material	:
Written By	:	Due Date	: 04/11/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JD 08-10-22</u>		
Comment	: Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS sheet .080
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Comment: Qty.: 0.0945 sf(s)/Unit Total: 1.1340 sf(s)

304SS .080

Batch: 109358IB 8-10-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3637

Dwg Rev: BProg Rev: BIB 8-10-22(12)

2-Deburr if necessary

IB 8-10-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-10-22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SOB 08/10/23(12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3637

SOB 08/10/24(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 1:31:59 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42822

Part Number: D3637041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS21059L4 Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nutplate

BATCH: M106322

FF 08/10/27 (12)

7.0 MS20426AD33 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Rivet

BATCH: M1563

FF 08/10/27 (12)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

2-C'Sink as per Dwg D3637

1 drill holes as per drawing using AT8979

3-Install Nut plate as per Dwg D3637

FF 08/10/27 (12)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/27 (X11)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 261

8/10/27

(12x) SC

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/27

Job Completion



W 08/10/27

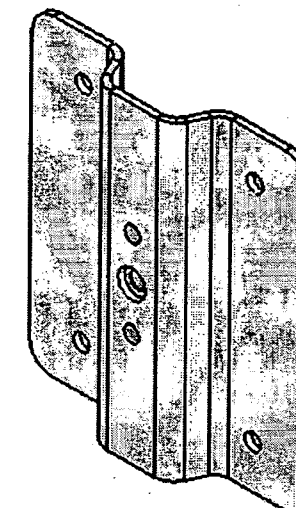
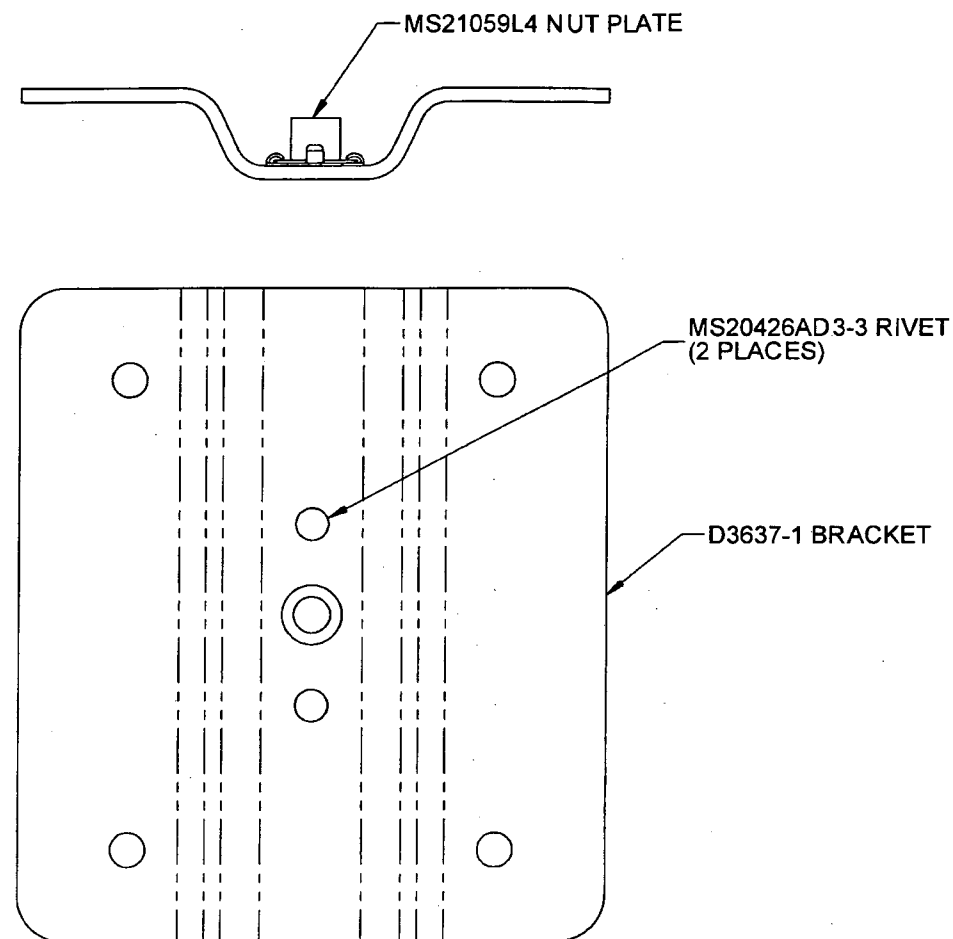
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)**

D3637-041 PARTS:

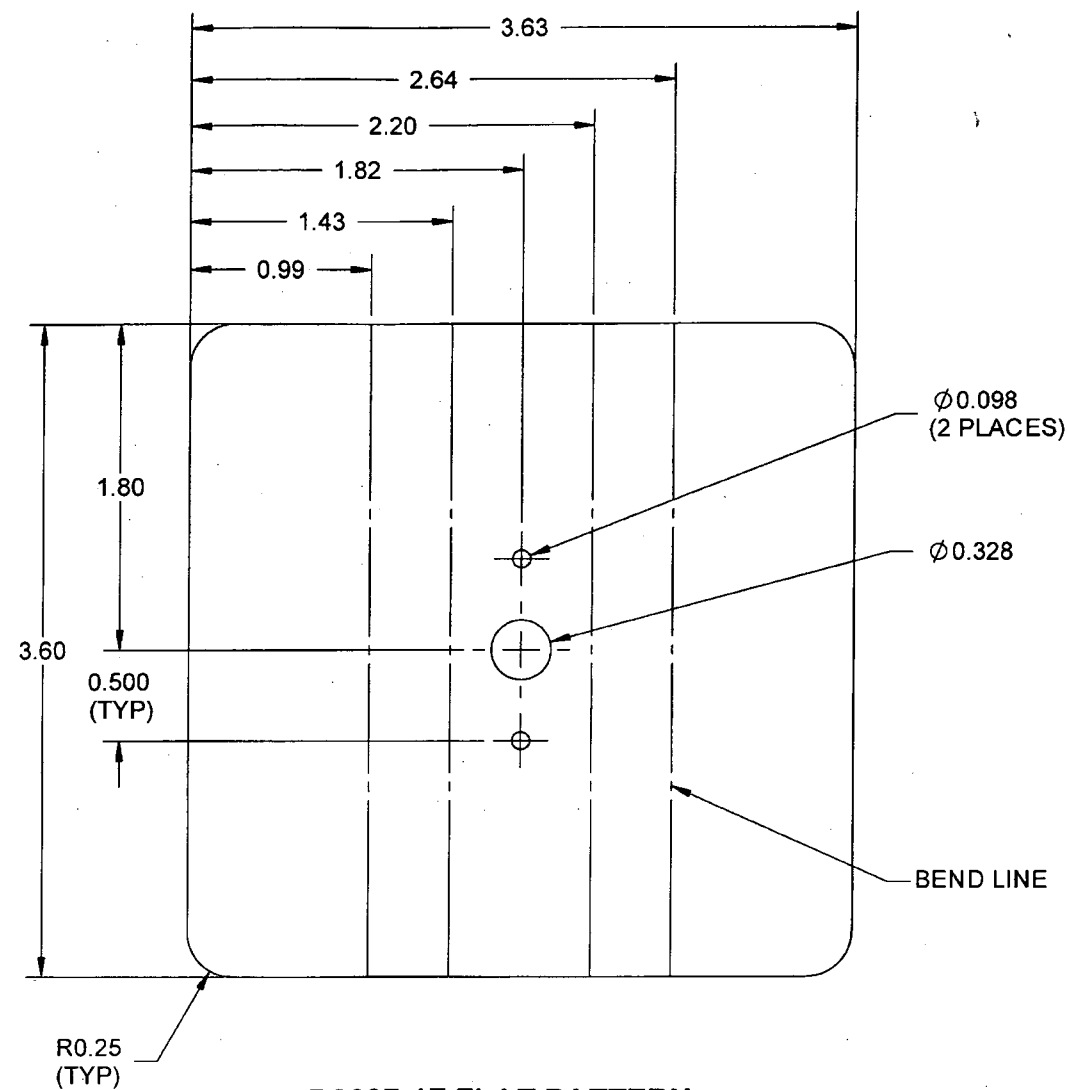
QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

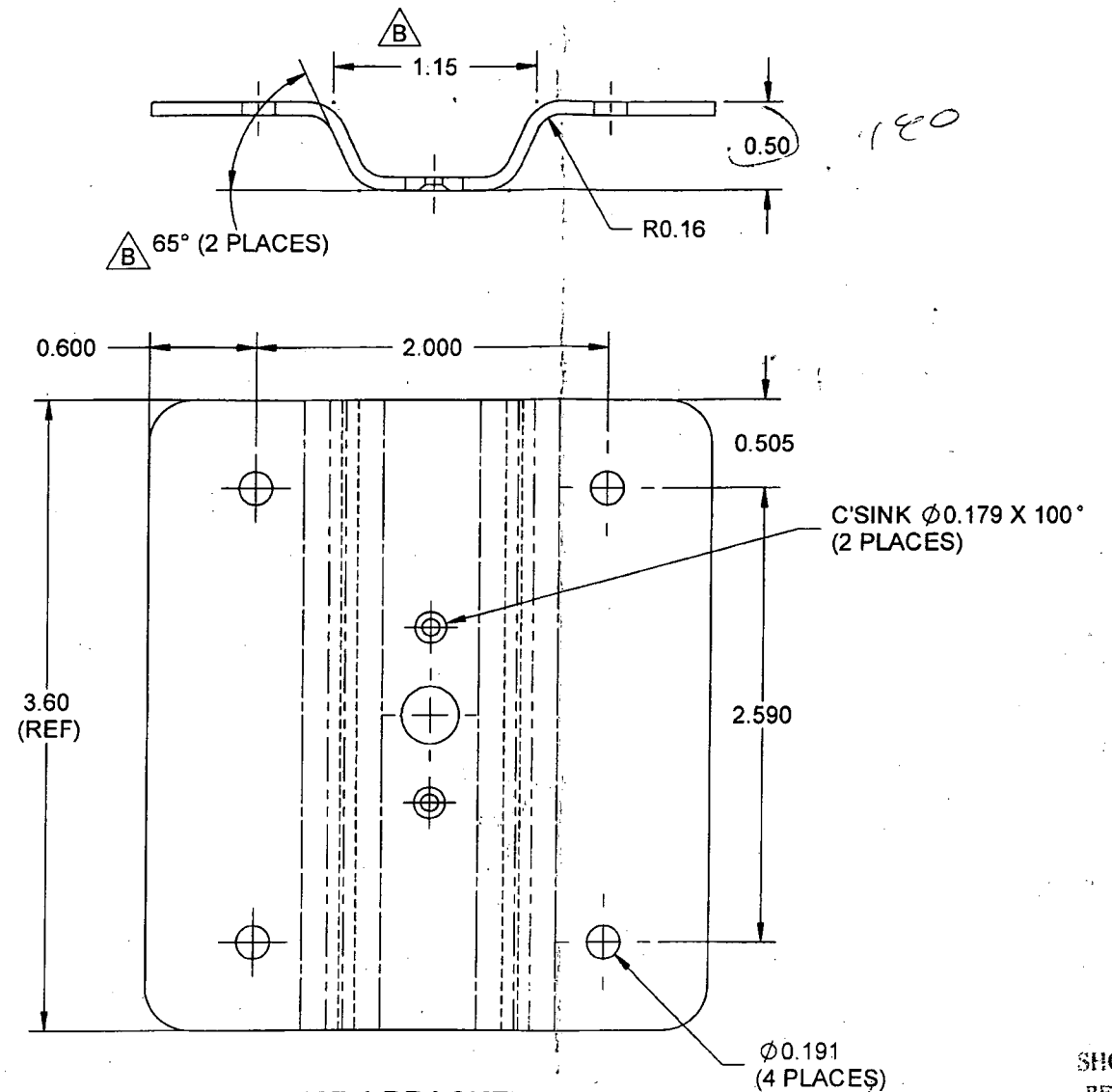
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

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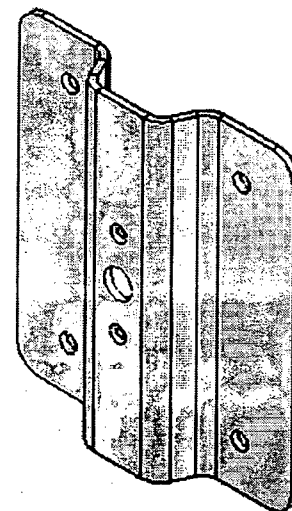
B	FOR D3637-1, 1.15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	EP	D3637	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	JS	BRACKET	1:1
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D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**

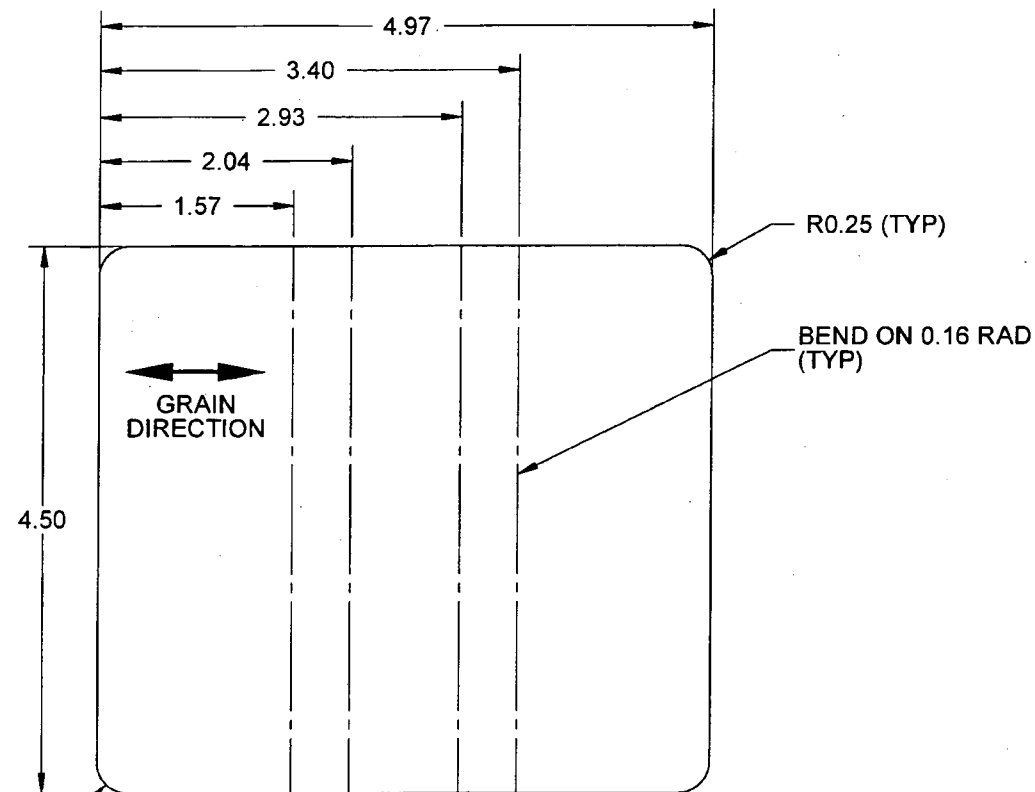


- D3637-1 NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

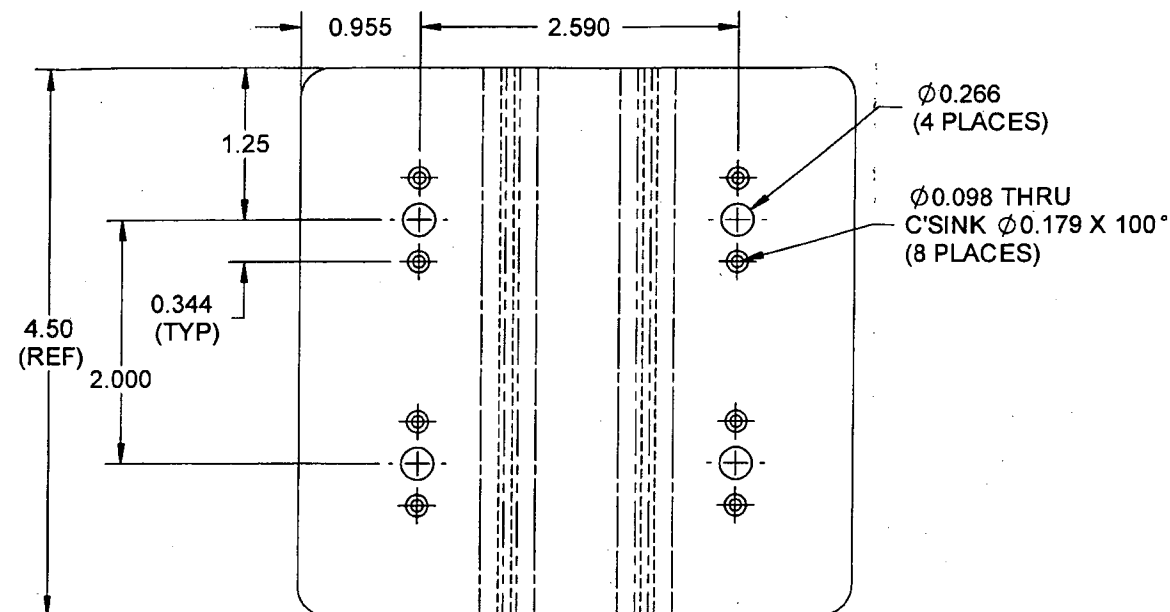
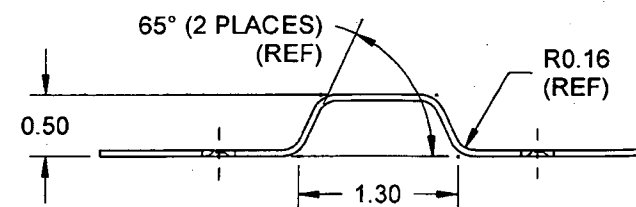
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO. D3637	REV. B
MFG. APPR.	130	SHEET 2 OF 3	
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DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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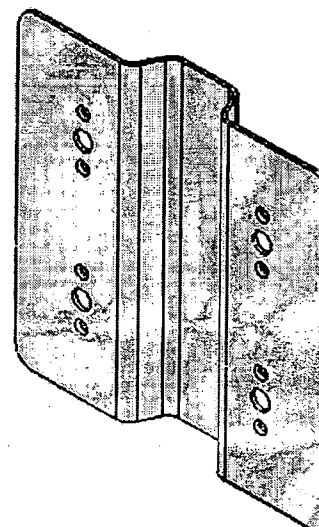
RELEASED
 08-22-09
 42822



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



- D3637-3 NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
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MFG. APPR.	EJ	D3637	SHEET 3 OF 3
APPROVED	M	TITLE	SCALE
DE APPR.	W	BRACKET	2:3
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